



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Avic

D350-591-133
Job Sheet 195589



Part No: D350-591-133

Job Qty: 10 pcs

Part Name: AFT Maintenance Step, Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/27/19

Job Tracking No:

Due Date: 8/9/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *Order 16671*

Note: DWG DSI9712 REV A , IIN-D350-591 REV H , D2946 REV.C IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	8/9/19		0.00	6.96	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
120	QC 6	10 pcs	8/9/19		0.00	0.00	QC 6 - 9		
							QC 6 - 68		
							QC 6 - 61		
							QC 6 - 40		
130	Large Fab - Welded Assy-2-B4B	10 pcs	8/9/19		0.00	6.96	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
140	QC 9	10 pcs	8/9/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		

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150	QC 5	10 pcs	8/9/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
160	Handfinish - 1-1 Chemical- B4B	10 pcs	8/9/19	0.00 1.52	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
170	QC 7	10 pcs	8/9/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	

				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
180 Large Fab - Welded Assy-3-B4B	10 pcs	8/9/19	0.00 6.96	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	DAS 43 9-89
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
190 QC 10	10 pcs	8/9/19	0.00 0.00	Large Fab - 9 - B4B	
				QC 10 - 10	
				QC 10 - 18	DAS 24 9-89
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
200 QC 5	10 pcs	8/9/19	0.00 0.00	QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	DAS 24 9-89
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
210 Handfinish - 1-2- Chemical-B4B	10 pcs	8/9/19	0.00 1.52	Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	

DAS
43
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JUN 18 2019

JUN 18 2019

JUN 19 2019

				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
220	Powdercoat - 1 White Gl(A)-B4B	10 pcs	8/9/19	0.00 1.04	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
230	Handfinish - 3-1- WingWalk-B4B	10 pcs	8/9/19	0.00 1.25	Handfinish - 3 - 1 - B4B
					Handfinish - 3 - 2 - B4B
					Handfinish - 3 - 3 - B4B
					Handfinish - 3 - 4 - B4B
					Handfinish - 3 - 5 - B4B
240	QC 3	10 pcs	8/9/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
250	Packaging 1-1 - Pick Kit - B4B	10 pcs	8/9/19	0.00 0.00	Packaging 1 - 1 - B4B
					Packaging 1 - 2 - B4B

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				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	PC JUL 0 2 2019
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	10 pcs	8/9/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
270 Packaging 3-1 - Stock - B4B	10 pcs	8/9/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	

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				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	JUL 02 2019
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	10 pcs	8/9/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	DAS JUL 02 2019
280 QC 21 - FG	10 pcs	8/9/19	0.00 0.00	QC 21 - FG - 21	21
				QC 21 - FG - 70	9-89 DAS JUL 02 2019
				QC 21 - SA - 53	21

Part Op 110 - (Fabricate per Dwg) 1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946 2- Drill vent hole as per dwg
 Descriptions: using DT10462 and c'sink.

- 120 - (QC6- All purchased or subcontracted products)
- 130 - (Weld per dwg A/R Aluminum rod Batch: 413562) 1-Deburr and Bevel ends for welding Use DT8440 jig
- 140 - (QC9- Inspect visual per QSI004- Fusion Welds)
- 150 - (QC5- Inspect part completeness to step on W/O)
- 160 - (Chemical Conversion Coat per QSI005 4.1)
- 170 - (QC7-Inspect Chemical Conversion Coat)
- 180 - (Weld per dwg A/R Aluminum rod Batch: 413037) 1- Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush. 2- Install rivet in vent hole as per dwg
- 190 - (QC10- Inspect visual per QSI004- ground welds)
- 200 - (QC5- Inspect part completeness to step on W/O)
- 210 - (Chemical Conversion Coat per QSI005 4.1)
- 220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
- 230 - (Wing Walk as per dwg QSI005 4.4 Batch _____)
- 240 - (QC3- Inspect Part Finish)
- 250 - (Pick Kit)
- 260 - (QC4- 100% Inspect kits for completeness)
- 270 - Identify and pack for shipping as per PPPD350-591-133 Location:FG038
- 275 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-133 CHG004
- 280 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	10 pcs (1 ea)	110-Large Fab - Steps - 1	✓ 5130307
D2734	Step End Plate	20 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	✓ 5160063
D2944	Step Mounting Plate	20 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	✓ 5077402
MS20601-AD4W2	Rivet	10 Ea (1 ea)	180-Large Fab - Welded Assy-3- B4B	5173408
AN4-11A	Bolt	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5179658
AN4-16A	Bolt	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5180311
AN4-7A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5107746
D2230-1	Mounting Lug	40 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5178277
D2230-3	Mounting Lug	40 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	51794368 5176022x24
D2732-030	Rubber Cushion - 3"	80 pcs (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	51761342 5190185 5174704 x19
D2945	Mounting Plate	10 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5078919
D3338-1	Mounting Lug	10 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5176031
MS21042L4	Nut	140 Ea (14 ea)	250-Packaging 1-1 - Pick Kit - B4B	5157064
NAS1149D0463J	Washer	140 Ea (14 ea)	250-Packaging 1-1 - Pick Kit - B4B	5174671

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	10	139	0
130-Large Fab - Welded Assy-2- B4B	D2734	20	54	0
	D2944	20	22	0
180-Large Fab - Welded Assy-3- B4B	MS20601-AD4W2	10	120	0
250-Packaging 1-1 - Pick Kit - B4B	AN4-11A	40	122	0
	AN4-16A	80	545	0
	AN4-7A	20	84	0
	D2230-1	40	194	0
	D2230-3	40	214	0
	D2732-030	80	43	0
	D2945	10	25	0
	D3338-1	10	86	0
	MS21042L4	140	2,342	0
	NAS1149D0463J	140	3,545	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

-DART
AEROSPACE

Container No: S188491

Part: D350-591-133

Job No: 195589

Serial No/Batch: S188491

Revision:

Inspector:

Exp Date:

Instructions:

TC STC SH92-6 Issue 16at F.A.M. STC SH967NI

UNIT Aerospace Ltd.
1270 Aberdeen Street
Newbury, ON K8A 1K7
CANADA
TEL: 513 632-5200
Email: sales@dartaero.com
www.dartaerospace.com